

Work Order ID 109202

November-14-13 10:19:09 AM

109202

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Item ID: D4842-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Lower Cutter Assembly

Start Date: 11/14/13 Start Qty: 1.00

1

Cust Item ID:

Required Date: 11/15/13 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: 

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

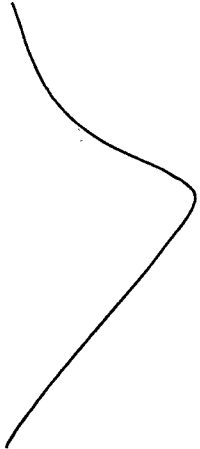
Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4842	REV B								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120		0.00							
120									
Small Fab	Memo	0.00							
Small Fab	Assemble as per dwg and apply loctite 598 on all faying surfaces.								
	A/R LOCTITE 598: <u>125306</u>								
130	QC5- Inspect part completeness to step on W/O	0.00							
130									
QC	Memo	0.00							
Quality Control									


DAS
05
13-11-15
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Item ID: D4842-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Lower Cutter Assembly
 Start Date: 11/14/13 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 11/15/13 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Identify as per dwg & Stock Location: _____	0.00							
140									
Packaging	Memo	0.00				①		13-11-15	
Packaging									
150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.00							
Quality Control									

PP 109197

13/11/18

1311-15

Picklist Print

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Work Order ID: 109202

Parent Item: D4842-041

Parent Item Name: Lower Cutter Assembly

Start Date: 11/14/13

Required Date: 11/15/13

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 13.04.30 NEW ISSUE DD VERF:JLM
DWG REV.B DD VERF:JLM

IPP REV:B 13.11.01 AS PER

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4839-1 Blade		Manufactured	No				Each	2.0000		2		11/11/15	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				prelim		2							
				100706		2							
D4842-1 Lower Cutter Deflector		Manufactured	No				Each	0.0000					
D4842-3 Lower Cutter Body, LH		Manufactured	No				Each	4.0000		1		11/11/15	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST123		4							
				107957		4							
D4842-4 Lower Cutter Body, RH		Manufactured	No				Each	4.0000		1		11/11/15	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST136		4							
				108070		4							
MS21042L08 Nut		Purchased	No				Each	5,126.0000		6		11/11/14	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST314		1659							
				122141		3							
				122452		9							
				122814		40							
				123900		107							
				m127410		1500							
				ST505		2000							
				125445		2000							
				ST509		1467							
				m127304		1467							

B# 109204

B# 107947 1 11/11/15

1 11/11/15

B# 107957

1 11/11/15

B# 108070

6 11/11/14

127304

Picklist Print

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Work Order ID: 109202

Parent Item: D4842-041

Parent Item Name: Lower Cutter Assembly

Start Date: 11/14/13

Required Date: 11/15/13

Start Qty: 1.00

Required Qty: 1.00

MS27039-08-19

Purchased

No

Each

2,882.0000

6

13-11-14

Screw

Location

Loc Qty

Loc Code

ST308

129

123525

89

m126474

40

ST309

403

125654

403

ST506

1150

m127305

750

m127410

400

st510

1200

124309

1200

NAS1149FN832P

Purchased

No

Each

13,774.000

12

13-11-14

Washer

Location

Loc Qty

Loc Code

ST295

3798

123522

398

123900

3400

ST510a

9976

125268

9976

123900

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Shop Packet Print

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8

7

6

5

4

3

2

1

D

C

B

A

MS21042L08
LOCKNUT

NAS1149FN832P WASHER

D4839-1 BLADE

D4842-3 LOWER
CUTTER BODY LH

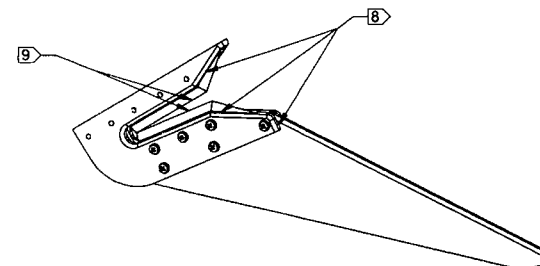
MS27039-0819 SCREW

NAS1149FN832P WASHER

D4842-4 LOWER
CUTTER BODY RH

D4842-1 LOWER CUTTER DEFLECTOR

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4842-041	LOWER CUTTER ASSY
1	2	D4839-1	BLADE
2	1	D4842-1	LOWER CUTTER DEFLECTOR
3	1	D4842-3	LOWER CUTTER BODY LH
4	1	D4842-4	LOWER CUTTER BODY RH
5	6	MS21042L08	LOCKNUT
6	6	MS27039-0819	SCREW
7	12	NAS1149FN832P	WASHER
8	A/R	LOCTITE 598	RTV SEALANT

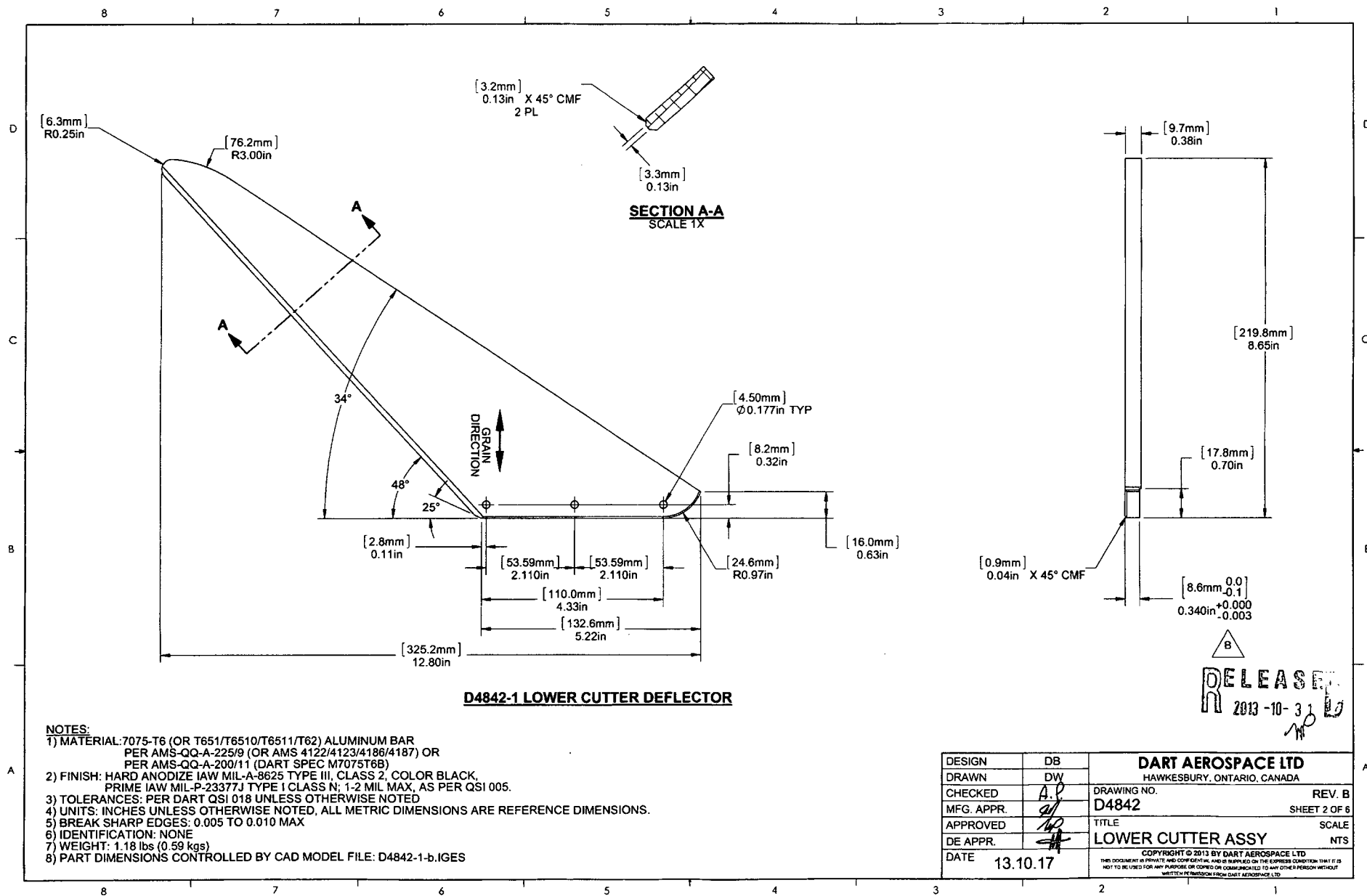
**D4842-041 LOWER CUTTER ASSEMBLY****NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: N/A
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4842-041", AGUSTA WESTLAND KIT NUMBER "TBD", REVISION, BATCH NUMBER AND MANUFACTURE DATE, USING AN X-TENSION STAMP, AS PER QSI 044 METHOD 6.2
- 7) WEIGHT: 2.79 lbs (1.26 KGS)
- 8) APPLY RTV SEALANT TO ALL FAYING SURFACES UPON ASSEMBLY
- 9) CUTTING EDGE INTENDED TO BE SHARP. DO NOT BREAK SHARP EDGE.

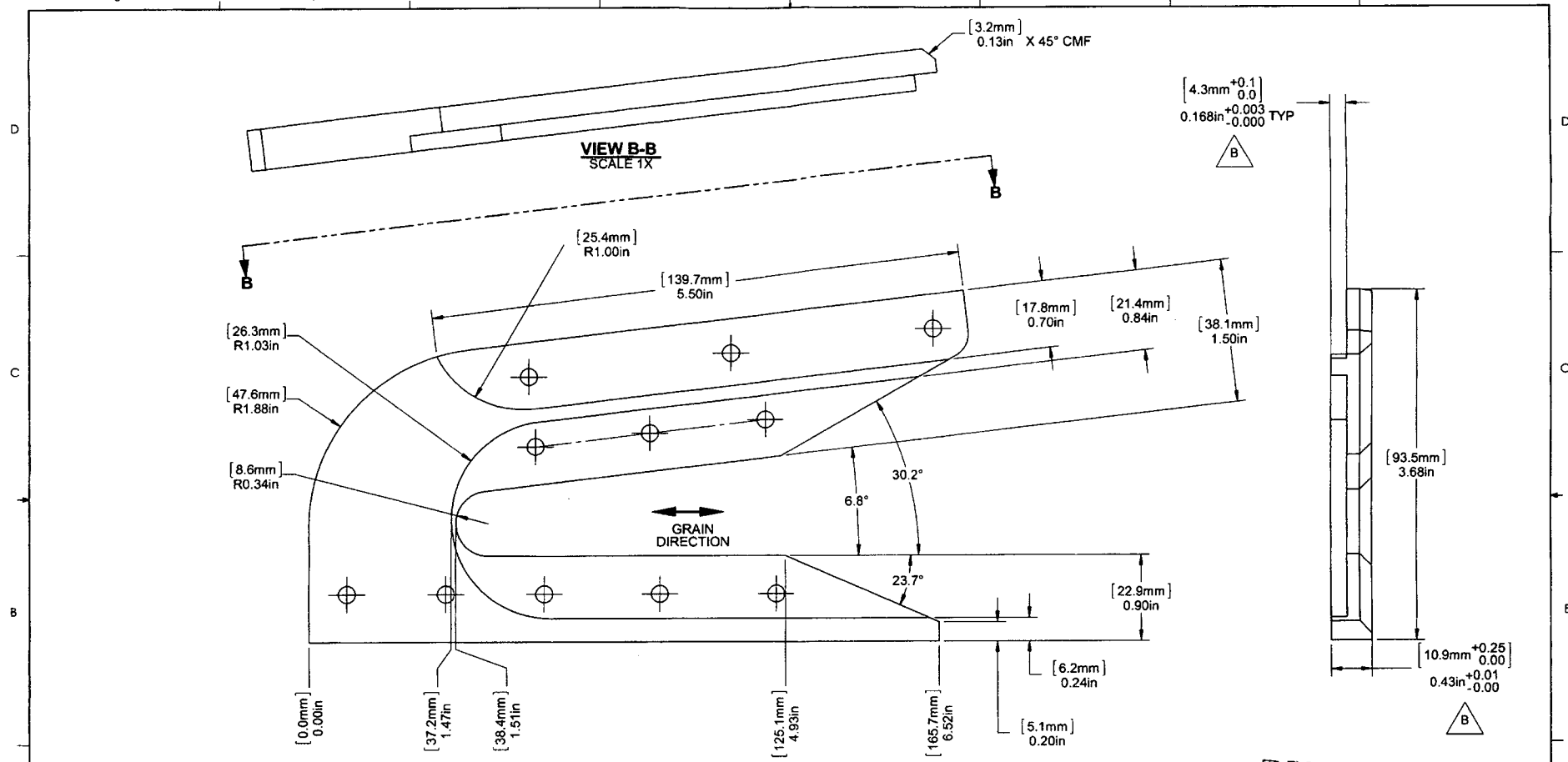
Handwritten: 4/6 109202

RELEASED
2013-10-31

B	CORRECT TOLERANCES (ZN B1-2) (ZN B1-3, D2-3) (ZN B7-5, D7-5)	DW	13.10.17
A	NEW RELEASE	DB	13.05.23
REV.	DESCRIPTION	BY	DATE
DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DW		
CHECKED	A.P.	DRAWING NO.	REV. B
MFG. APPR.	2/	D4842	SHEET 1 OF 6
APPROVED	1/2	TITLE	SCALE
DE APPR.	1/2	LOWER CUTTER ASSY	NTS
DATE	13.10.17	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



8 7 6 5 4 3 2 1



D4842-3 LOWER CUTTER BODY LH

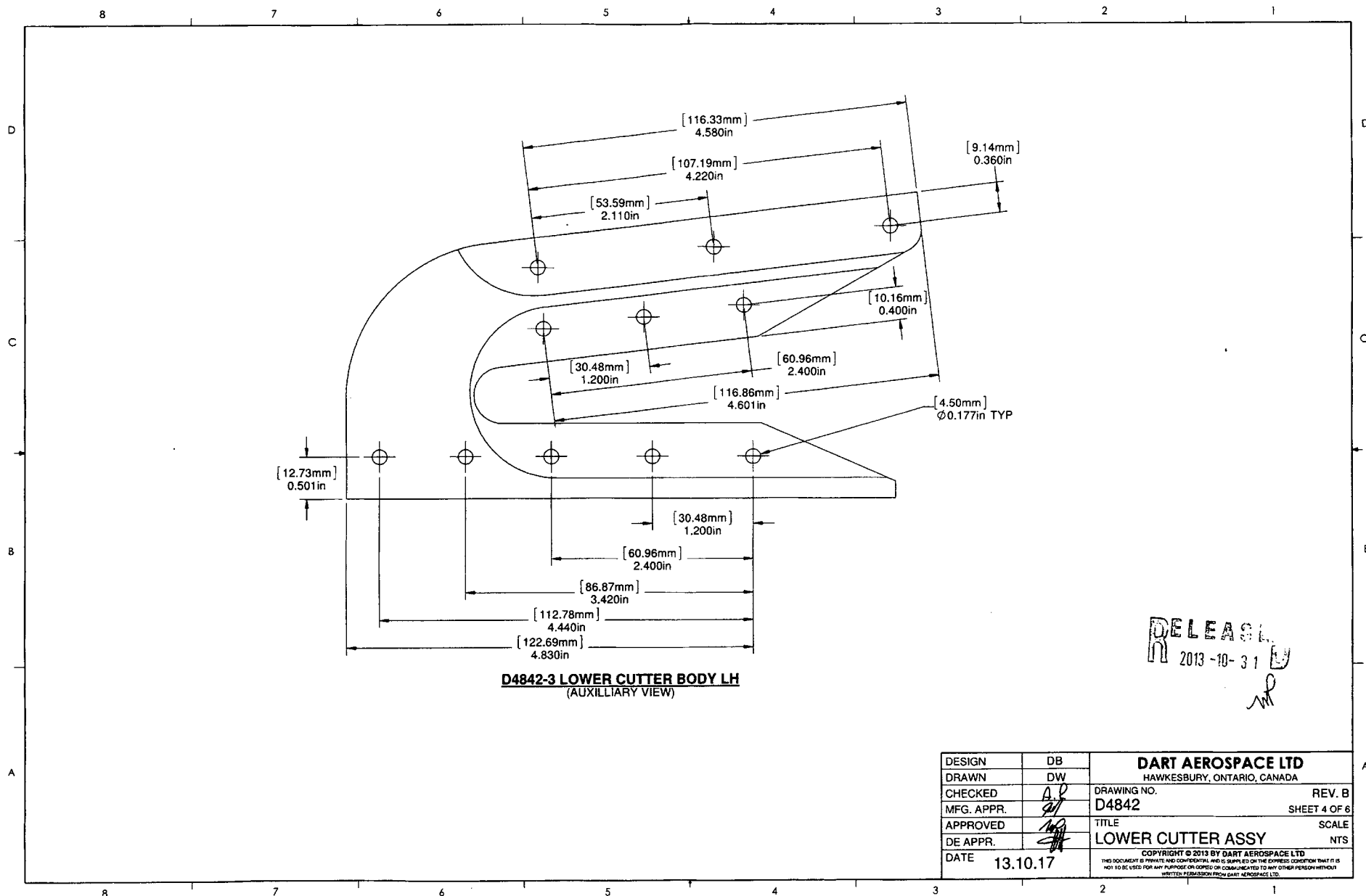
NOTES:

- 1) MATERIAL: 7075-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR
PER AMS-QQ-A-225/9 (OR AMS 4122/4123/4186/4187) OR
PER AMS-QQ-A-200/11 (REF DART SPEC M7075T6B)
- 2) FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOR BLACK, AS PER QSI 017;
PRIME IAW MIL-P-23377J TYPE I CLASS N; 1-2 MIL MAX, AS PER QSI 005.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED, ALL METRIC DIMENSIONS ARE REFERENCE DIMENSIONS.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.49 lbs (0.22 kgs)
- 8) PART DIMENSIONS CONTROLLED BY CAD MODEL FILE: D4842-3-b.IGES

RELEASED
2013-10-31

DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DW		
CHECKED	A.P.	DRAWING NO. D4842	REV. B
MFG. APPR.	2/	SHEET 3 OF 6	
APPROVED	1/2	TITLE LOWER CUTTER ASSY	SCALE
DE APPR.	1/2	NTS	
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8 7 6 5 4 3 2 1



RELEASE
2013-10-31
[Signature]

DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DW		
CHECKED	A.P.	DRAWING NO. D4842	REV. B
MFG. APPR.	[Signature]	SHEET 4 OF 6	
APPROVED	[Signature]	TITLE	SCALE
DE APPR.	[Signature]	LOWER CUTTER ASSY	NTS
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